

Date: Tuesday, 1/3/2006 4:20:25 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE SPACER
Job Number	: 25378		
Estimate Number	: 11062		
P.O. Number	: N/A	Part Number	: D2934
This Issue	: 1/3/2006 S.O. No. : N/A	Drawing Number	: D2934 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: N/A	Material	: N/A
Written By	: SEE COMMENT BELOW	Due Date	: 1/28/2006
Checked & Approved By	: SEE ABOVE USER & DATE	Qty:	40 Um: Each
Comment	: Est A 00.06.06 New Issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S080	5052-H32 .080 Sheet
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Comment: Qty.: 0.0663 sf(s)/Unit Total: 2.6502 sf(s)
 Material: 5052-H32/H34 (QQ-A-250/8) 0.080" Thick
 Batch M19052

J.L 06-02-04

2.0	SHEAR	SHEAR
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Comment: SHEAR
 1 blank makes 4 parts
 Blank: 7.90" x 4.60" (+0.030" - 0.000")

J.L 06-02-04 (40)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine per folio FA072
 Tumble
 Deburr any rough edges after tumbling

SAD - 06-02-06 (40)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 06-02-04 40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *SD* Date: 06/03/21
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/3/2006 4:20:26 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE SPACER

Job Number: 25378

Part Number: D2934

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

En 06/02/04

40

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06/3/00 40

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 395

DOCUMENT CONTROL

06/3/00

40

9.0

DC



Comment: DOCUMENT CONTROL

Inspection Level 21

06/03/01 40

Job Completion



06.03.21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

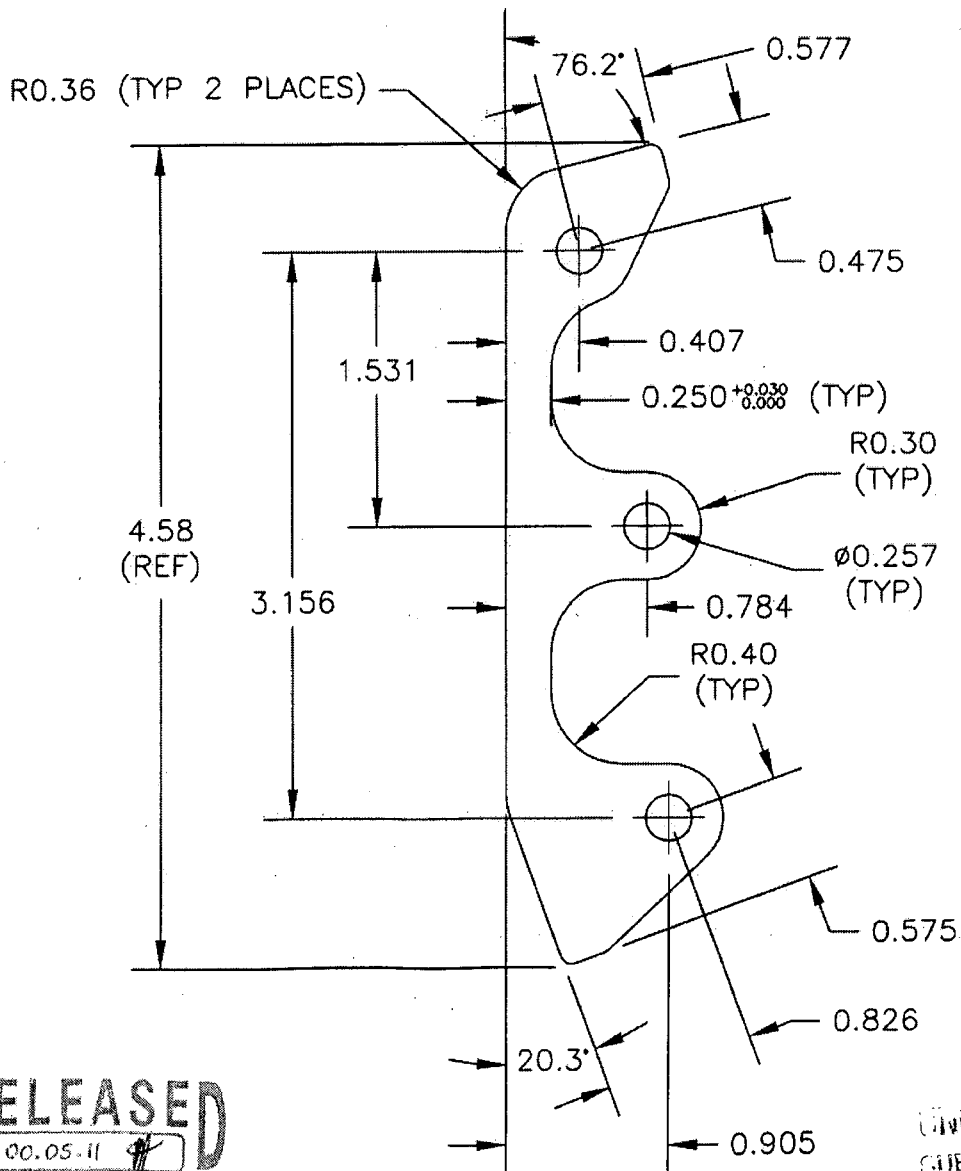
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2934	REV. A SHEET 1 OF 1
DATE 99.11.02	TITLE SADDLE SPACER		SCALE 1:1
A	99.11.02	NEW ISSUE	



RELEASED
00.05.11 *[Signature]*

REVIEWED
RETURNED
ENGINEERING
UNCONTROLLED
SUBJECT TO A
WITHOUT NOT
WORK ORDER
NO. 25378

MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.080 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
BREAK ALL SHARP EDGES 0.010 TO 0.020